

**SEGMENT TYPE HONEYCOMB BRAZING METHOD AND JIG FOR HONEYCOMB BRAZING**

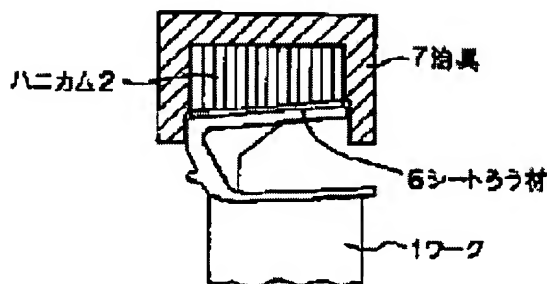
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**Abstract of JP9010926**

**PROBLEM TO BE SOLVED:** To omit a tack welding and to secure a prescribed curvature by welding while restricting a honeycomb with a jig and closely contacting with the whole range of brazing surface after sticking a sheet brazing filling metal to the brazing surface of a stationary blade, at the time of brazing the honeycomb for air seal at the tip part of the stationary blade of an axial compressor.

**SOLUTION:** Firstly, the sheet brazing filler metal 6 having a suitable thickness is stuck to the whole range of the brazing surface of the stationary blade 1. Successively, in order to execute the positioning, the jig 7 inserting the honeycomb 2 is fitted to both end surfaces of the stationary blade 1 and the jig 7 functions as a weight and the honeycomb 2 is closely stuck to the whole range of the brazing surface and charged into a heating furnace under this state and welded. By this method, an embedding work of the sheet brazing material into the honeycomb 2 is unnecessitated and further, a spot tack welding between the stationary blade 1 and the honeycomb 2 is unnecessitated and the development of defect caused by the tack welding can be avoided. Further, ceramic coating is applied on the inner surface of the jig 7 to avoid the welding between the stationary blade 1 and the honeycomb 2.



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